

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021590**Date Inspected:** 18-Feb-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1500**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. Xu Le Feng.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower and Orthotropic Box Girder (OBG)**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance (QA) Inspector Shailesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

This QA Inspector observed the following work in progress:

BAY 10: FCAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 054069, Perform Flux Core Arc Welding (FCAW) on OBG Traveler Rail. Joint identified as 3005TR3-008, 007. ZPMC QC Identified as Yin Chun Fang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB. For more information see attached picture number 1.

Tower Lift 6: FCAW Process,

This QA Inspector observed ZPMC qualified welding personnel identified as 040458, Perform Flux Core Arc Welding (FCAW) on Tower lift 6 Diaphragm plate. Joint identified as NSD1-DPSA6-3-1, 2. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2233-ESAB. For more information see attached picture number 2.

SMAW Process:

This QA Inspector observed ZPMC qualified welding personnel identified as 053829, Perform Shielded Metal Arc

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Welding (SMAW) on OBG Bike path pipe support angles. Joint identified as BK004A-032-MEP04, MEP013. ZPMC CWI Identified as Guo Yan Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2112, and WPS-B-P-2113.

This QA Inspector observed ZPMC qualified welding personnel identified as 044511, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path. Joint identified as BK008A3-001-010. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-U4c.

This QA Inspector observed ZPMC qualified welding personnel identified as 052930, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike path. Joint identified as BK008A5-001-008. ZPMC QC Identified as Li Peng Fei. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-P-2211-U4c.

Repair Welding SMAW process:

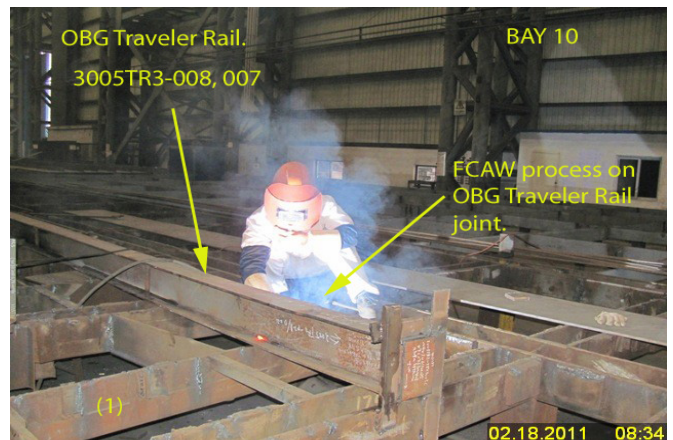
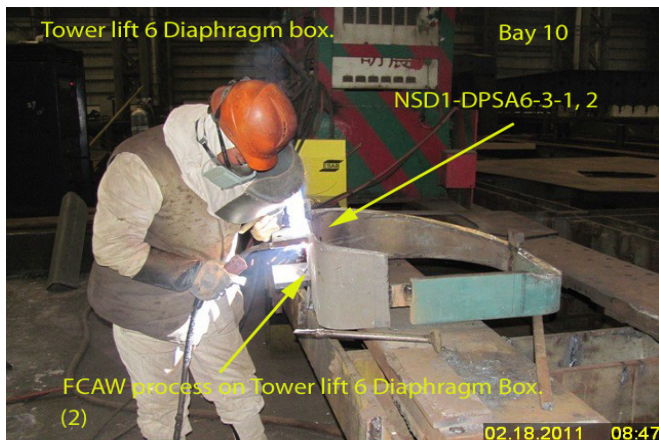
This QA Inspector observed ZPMC qualified welding personnel identified as 057258, Perform Shielded Metal Arc Welding (SMAW) on OBG Bike Path Sole Plate. Bike path plate identified as BK007A-001 approximately weld build up 30mm on edge. ZPMC QC Identified as Li Peng Fei with temporary welding repair report WRR-B-WR 16924. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-345-SMAW-2G (2F) Repair. For more information see attached picture number 3.

BAY 11,

FCAW Process:

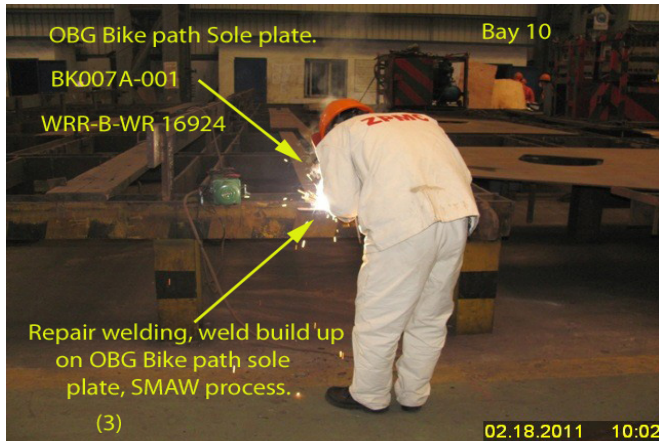
This QA Inspector observed ZPMC qualified welding personnel identified as 040736, Perform Flux Core Arc Welding (FCAW) on OBG Bike path Sole plate. Joint identified as BK004A1-064-038, 036, 037. ZPMC QC Identified as Shao Hai Lang. The welding parameters as measured using QC's calibrated instrument appeared to be in general compliance with WPS-B-T-2132-ESAB.

Unless otherwise noted, all work observed on this date appeared to be in general compliance with the applicable contract documents.



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Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Thomas Ho: 150002048250, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Shailesh	Quality Assurance Inspector
Reviewed By:	Clifford,William	QA Reviewer
